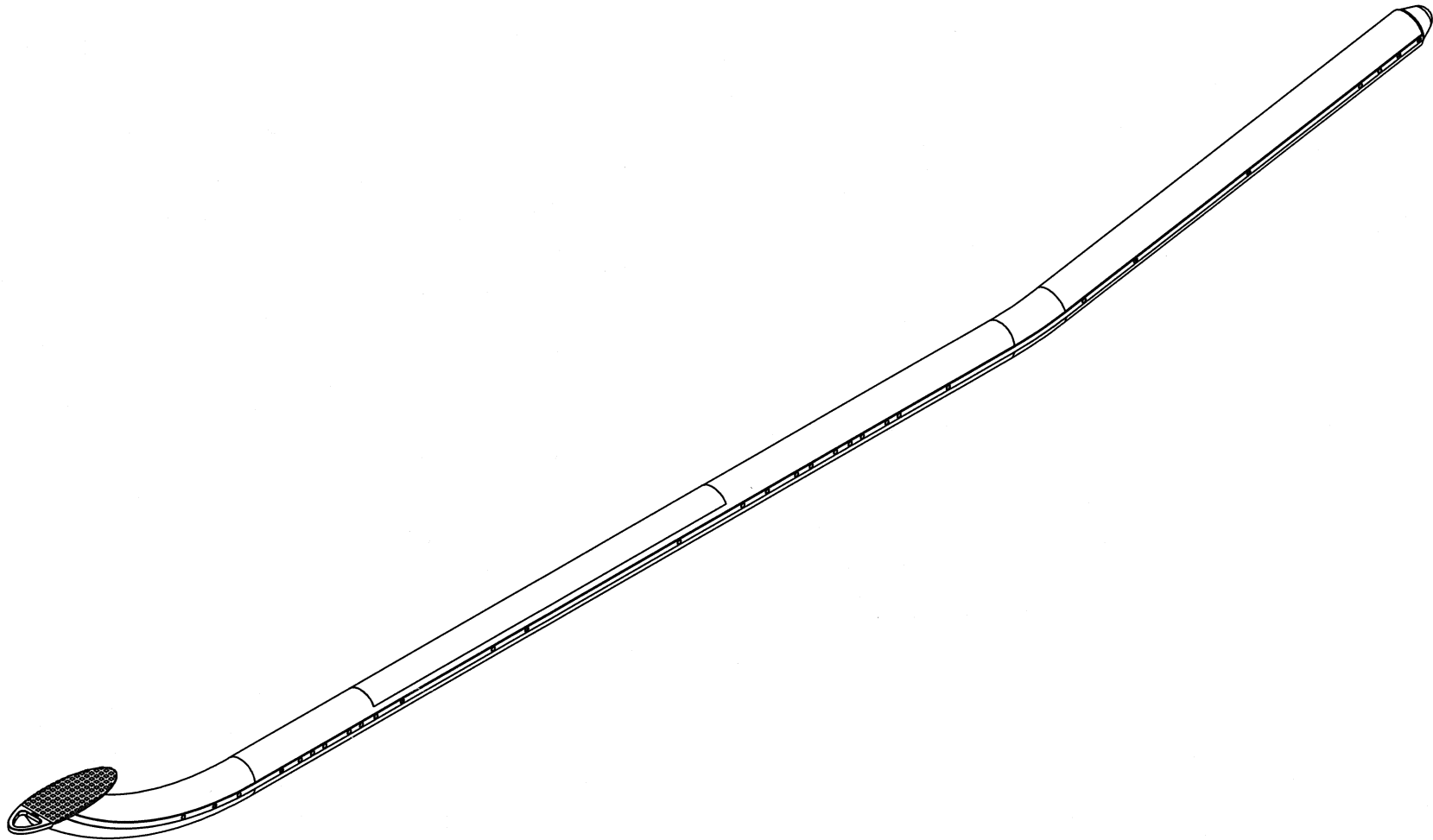


QTY -041	PART NUMBER	DESCRIPTION
X	D5634-041	FLOAT SKIDTUBE ASSEMBLY
1	D2646	AFT CAP
7	D3275-1	SPACER
23	D4720-1	SPACER
1	D5633-1	TOW STEP
1	D5634-1	FLOAT SKIDTUBE
1	D5636-041	FLOAT WEB ASSEMBLY
2	MS24693-C272	SCREW, CSK 100°



D5634-041 FLOAT SKIDTUBE ASSEMBLY

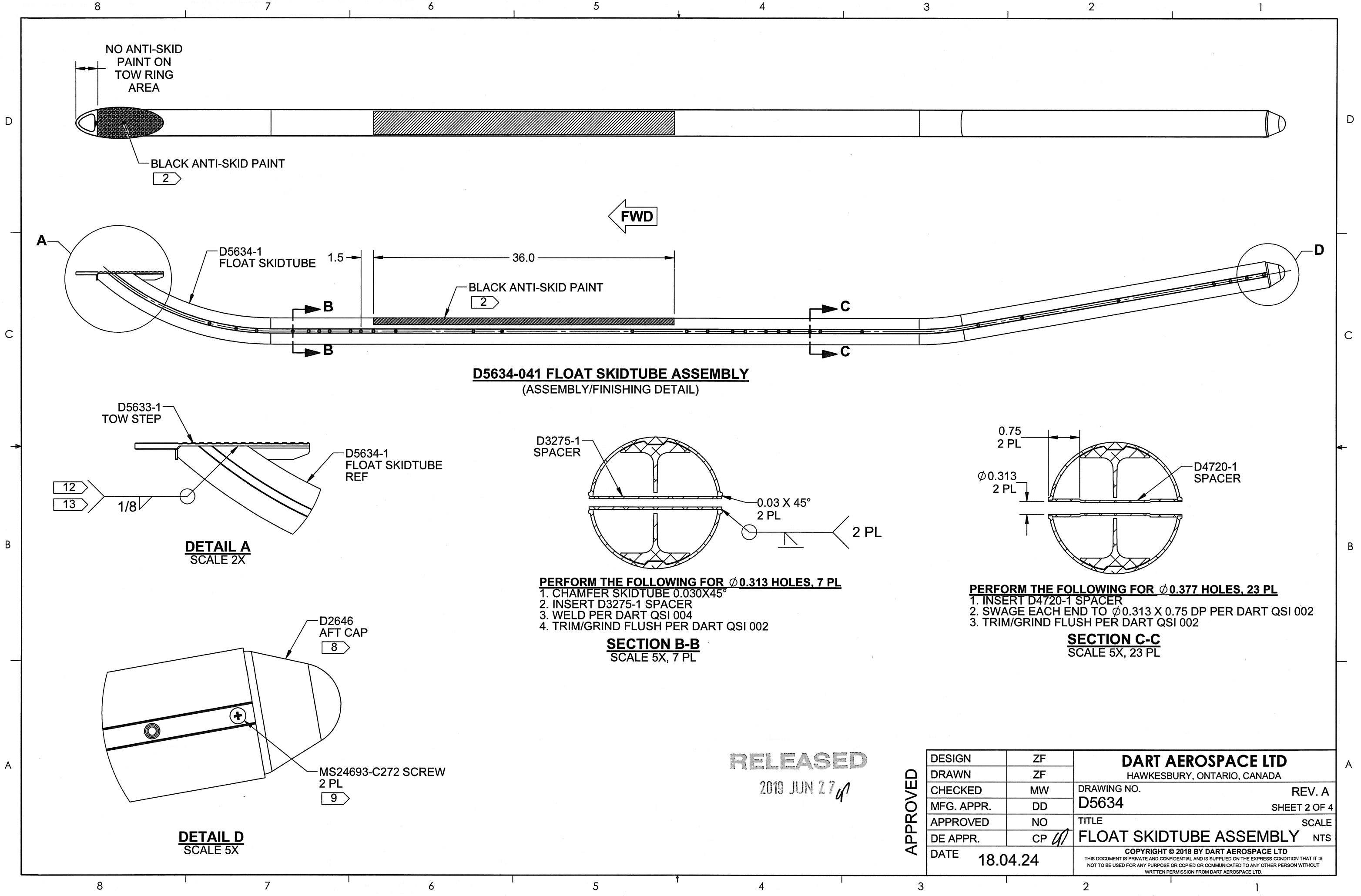
- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)  
PAINT GLOSS BLACK PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)  
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
  - 3) TOELRANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.4 ON INNER TUBE SURFACE AT AFT END.
  - 7) WEIGHT: 21.03 lb
  - 8) SEAL MATING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL P/S 890/1422 OR MIL-S-8802 CLASS B2 SEALANT
  - 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-291 OR PROSEAL P/S 890/1422 OR MIL-S-8802 CLASS B2 SEALANT
  - 10) INSTALL WEB INTO OUTER TUBE WITH SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015.  
LOCATE AS SHOWN, ENSURE DOUBLER END IS LOCATED AT AFT BEND REGION
  - 11) DAMAGE TOLERANCE ON BENDS:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5" ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
  - 12) WELDING PER QSI 004.
  - 13) IT IS PERMISSIBLE TO GRIND SKIDTUBE TO IMPROVE FIT WITH TOW STEP. DIMENSIONS SHOWN AFTER GRINDING FOR TOW STEP.
  - 14) SLOT FOR D5633-1 TOW STEP THRU BACK WALL ONLY.

RELEASED

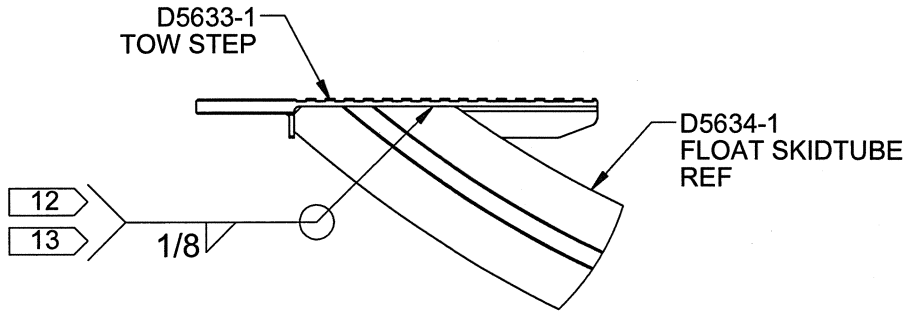
2019 JUN 27  
ECN 19-746

APPROVED

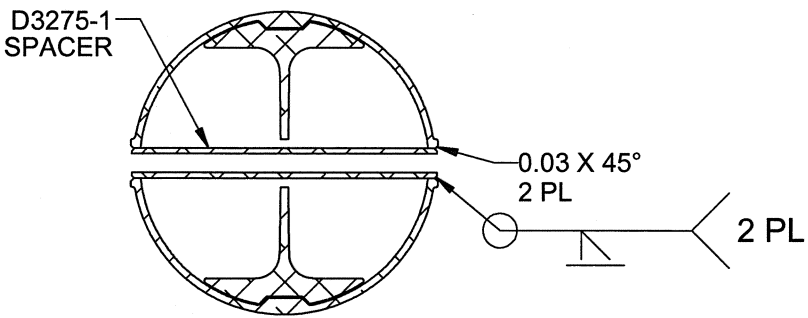
A	NEW ISSUE		ZF	18.04.24
REV.	DESCRIPTION		BY	DATE
DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	ZF			
CHECKED	MW	DRAWING NO.	REV. A	
MFG. APPR.	DD	D5634	SHEET 1 OF 4	
APPROVED	NO	TITLE	SCALE	
DE APPR.	CP	FLOAT SKIDTUBE ASSEMBLY	NTS	
DATE	18.04.24	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



**D5634-041 FLOAT SKIDTUBE ASSEMBLY**  
(ASSEMBLY/FINISHING DETAIL)

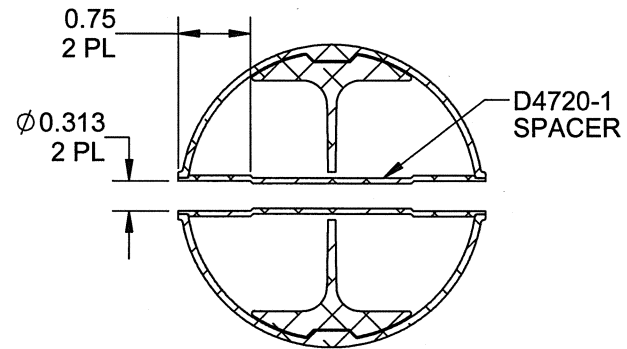


**DETAIL A**  
SCALE 2X



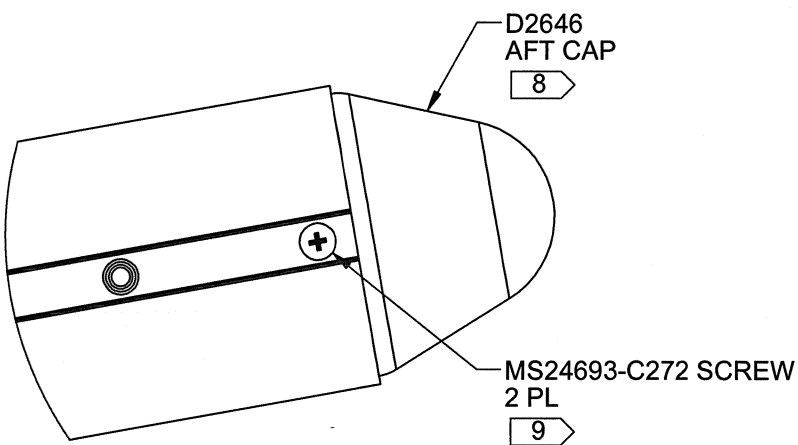
- PERFORM THE FOLLOWING FOR Ø0.313 HOLES, 7 PL**
- 1. CHAMFER SKIDTUBE 0.030X45°
  - 2. INSERT D3275-1 SPACER
  - 3. WELD PER DART QSI 004
  - 4. TRIM/GRIND FLUSH PER DART QSI 002

**SECTION B-B**  
SCALE 5X, 7 PL



- PERFORM THE FOLLOWING FOR Ø0.377 HOLES, 23 PL**
- 1. INSERT D4720-1 SPACER
  - 2. SWAGE EACH END TO Ø0.313 X 0.75 DP PER DART QSI 002
  - 3. TRIM/GRIND FLUSH PER DART QSI 002

**SECTION C-C**  
SCALE 5X, 23 PL

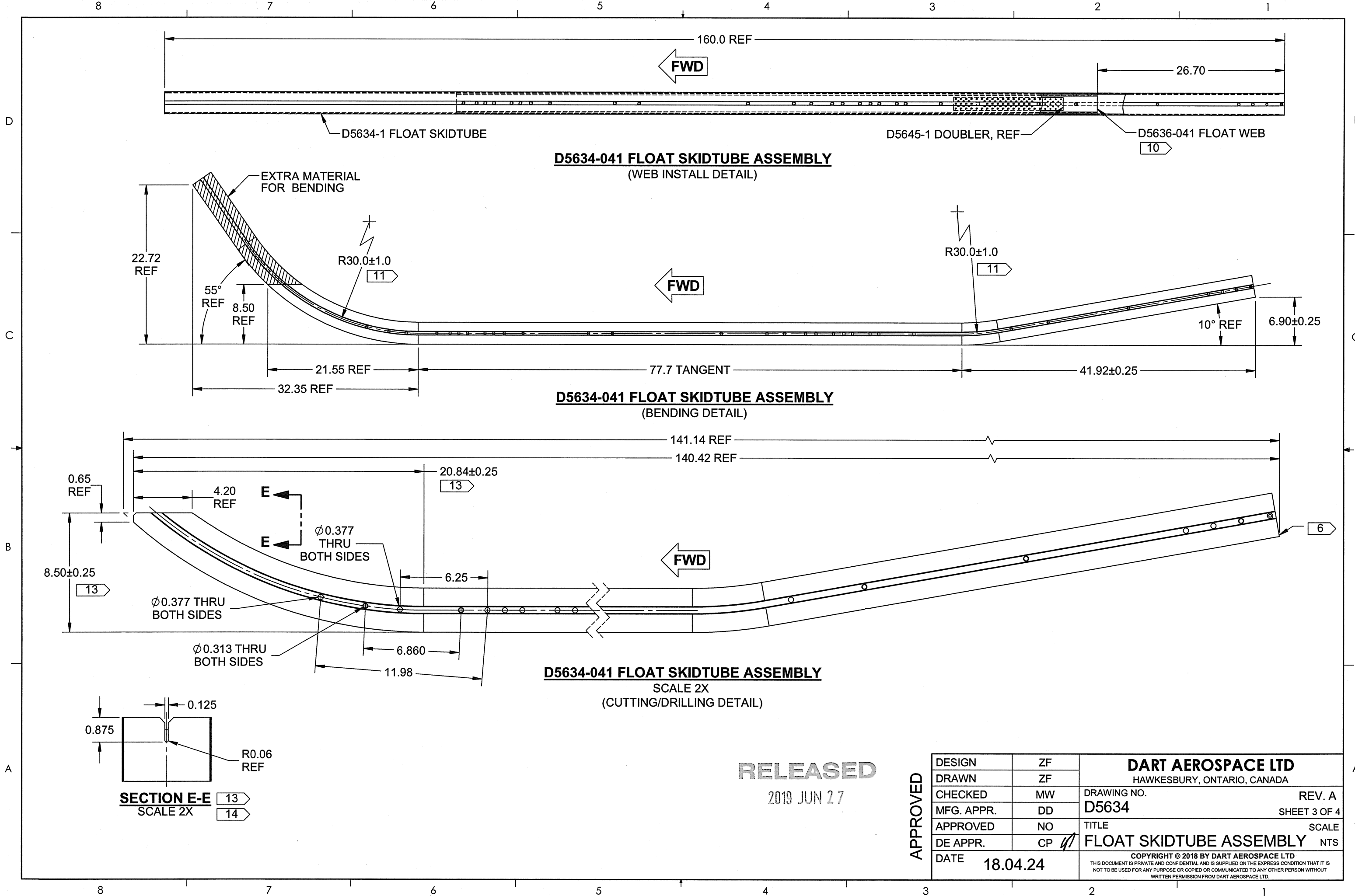


**DETAIL D**  
SCALE 5X

**RELEASED**  
2019 JUN 27

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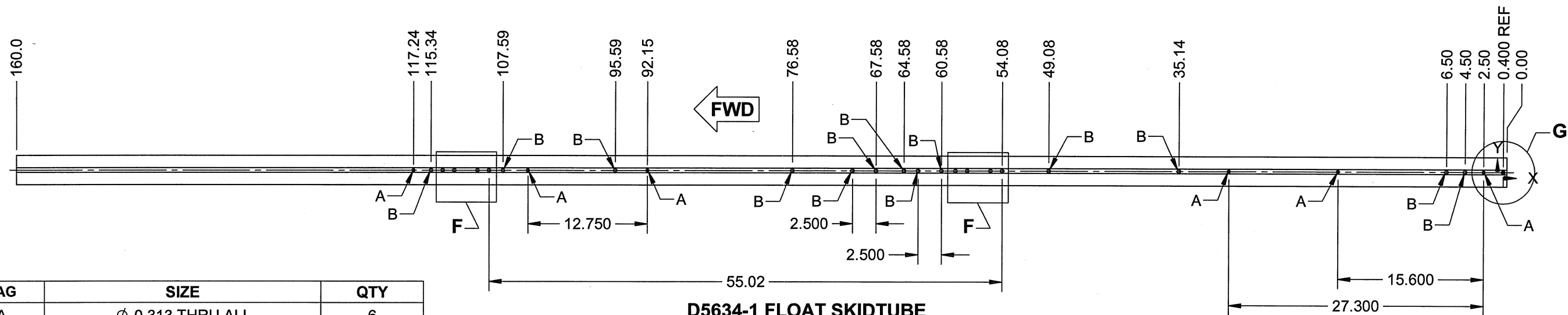
DESIGN	ZF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO. <b>D5634</b>	REV. A
MFG. APPR.	DD		SHEET 2 OF 4
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	<b>FLOAT SKIDTUBE ASSEMBLY</b>	NTS
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2019 JUN 27

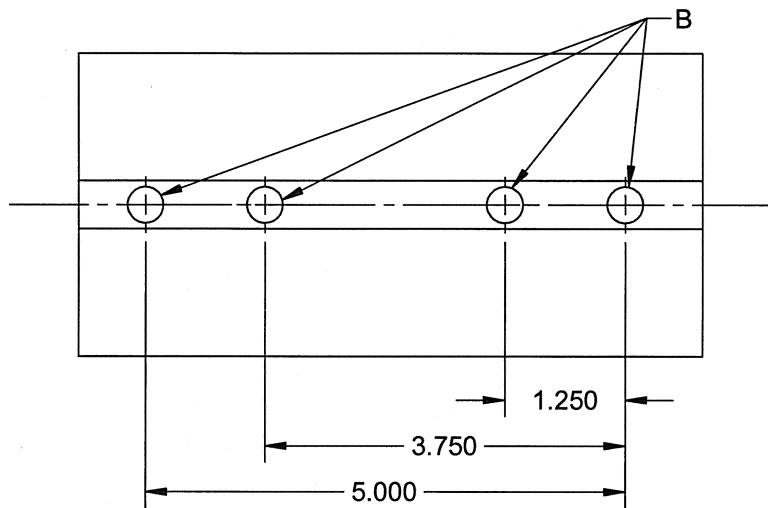
APPROVED

DESIGN	ZF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO. <b>D5634</b>	REV. A SHEET 3 OF 4
MFG. APPR.	DD	TITLE <b>FLOAT SKIDTUBE ASSEMBLY</b>	
APPROVED	NO	SCALE NTS	
DE APPR.	CP	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	18.04.24		

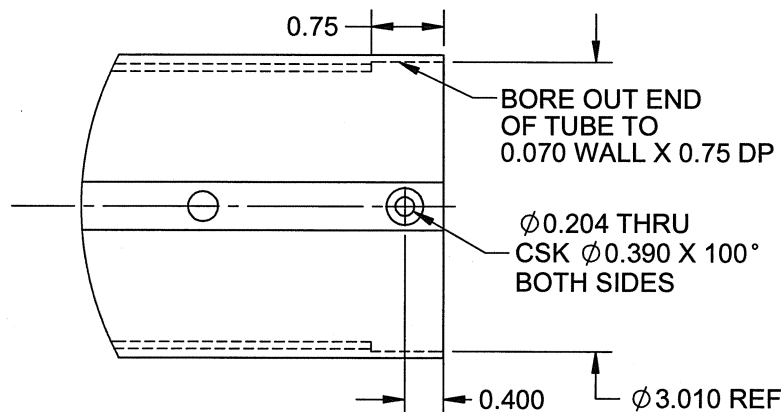


TAG	SIZE	QTY
A	Ø 0.313 THRU ALL	6
B	Ø 0.377 THRU ALL	21

**D5634-1 FLOAT SKIDTUBE**



**DETAIL F**  
SADDLE HOLE DETAIL  
SCALE 6X, 2 PL



**DETAIL G**  
SCALE 6X

- NOTES:**
- 1) MATERIAL: MAKE FROM D2600-1 EXTRUSION
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 12.34 lb

**RELEASED**  
2019 JUN 27

**APPROVED**

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ZF		
CHECKED	MW	DRAWING NO. D5634	REV. A SHEET 4 OF 4
MFG. APPR.	DD	TITLE SCALE FLOAT SKIDTUBE ASSEMBLY NTS	
APPROVED	NO		
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DATE	18.04.24		